

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027763**Date Inspected:** 13-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Andrew Keech**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

CCO 201 Tower elevation 31 Pad eye Install

This QAI observed the removal of paint by grinding at 12 locations at Tower elevation 31. Ground areas were clean to a bright metal condition, then layout, location lines to be used during Pad eye installation were scribed on the tower columns. Per CCO 201 each 12 total Pad eyes were to be installed at elevation 31.

After grinding and layout this QAI observed the base metal being preheated to a QC recorded and QA verified temperature of 250F. The preheating was accomplished utilizing a rosebud torch using propane as fuel. Preheat was verified by this QA utilizing a Tempil Stick.

As soon as preheating operations ceased the Pad eye was attached to the tower column by Welder Rory Hogan using the Shield Metal Arc (SMAW) Process utilizing an E7018H4R consumable electrode at a QC recorded, QAI verified 123 amps.

This QAI performed Visual Weld Inspection of the 12 Pad eye to Tower Column welds completed on this date. Welds were found to meet the requirements of AWS D1.5 Bridge Welding Code Visual Inspection Criteria.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

There were general conversations with Quality Control Inspector Andrew Keech, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Danny Reyes and Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By: Daggett, Matt

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer